

**Work Order ID 69437**

Page 1

Wednesday, May 11, 2011 10:09:34 AM

Item ID: D3741-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle

Start Date: 5/11/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

*H*

Date: 11-05-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3741

Rev B

100

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1-drill holes as per dwg D3741-2-Deburr

*11/05/19**(12)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*11/05/19**(2)*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*11-8-19**12*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID: D3741-1

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 5/11/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

Small Fab

0.00

H 11.05.20

12

Ø

Memo

0.00

Small Fab

1- Grind radius as per dwg D3741 □ 2- Deburr if necessary

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

J 11.05.20

12

Memo

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

H 11.05.20

12

Ø

Memo

0.00

W/O:		WORK ORDER CHANGES						
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# Work Order ID 69437

Wednesday, May 11, 2011 10:09:34 AM



Page 3

Item ID:	D3741-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Angle				Stop	
Start Date:	5/11/2011	Start Qty: 10.00		Cust Item ID:		
Required Date:	5/16/2011	Req'd Qty: 10.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00		SAD	11.05.20	(12)			
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u>  Memo	0.00  0.00			11.05.20	12	φ		
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00						11/5/24	

UMF  
11-05-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 11, 2011 10:09:42 AM

Page 1

Work Order ID: 69437

Parent Item: D3741-1

Parent Item Name: Angle



Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-01-30 new issue DD verified by:  
IPP Rev:B 08-03-19 chg to revB DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6207		Manufactured	No			110	f	0.0000	0.0625	0.657895			
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Angle Extrusion

M117 481



1.0 ft ~~20~~ 11/05/19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

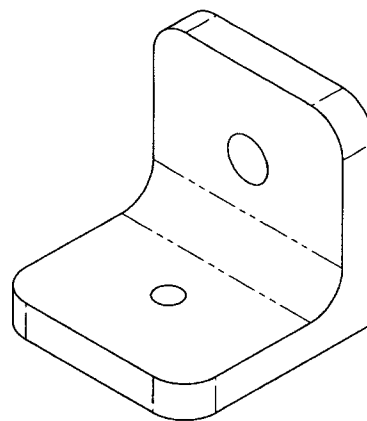
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**D3741-1 ANGLE** 

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69437

*011-05-11*

**NOTES:**

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.125  
PER AMS-QQ-A-200/8  
(REF. DART SPEC. M6061T6A750XW125) 
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

B	SHEET 1 NOTES DART SPEC IN MATERIALS UPDATED: ISO VIEW UPDATED. SHEET 2 ZONE D5, Ø0.098 HOLE WAS Ø0.159, ZONE 6B 0.440 DIM WAS 0.450.		AJS	08.03.06
A	NEW ISSUE		AJS	08.02.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	<i>CE</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>DS</i>	D3741	SHEET 1 OF 2	
APPROVED	<i>MP</i>	TITLE	SCALE	
DE APPR.	<i>MP</i>	ANGLE	NTS	
DATE	08.03.06	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

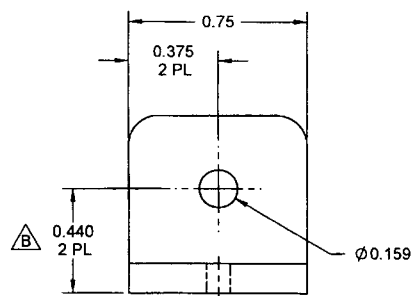
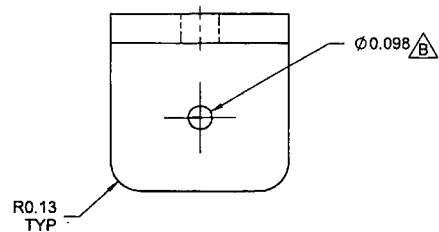
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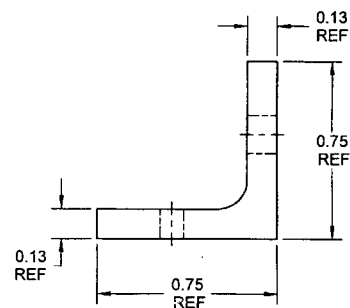
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**NOTE:** Date & initial all entries



**D3741-1 ANGLE**



u/069437

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CE	DRAWING NO. D3741	REV. B
MFG. APPR.	NS	SHEET 2 OF 2	
APPROVED	AP	TITLE	SCALE
DE APPR.	TH	ANGLE	NTS
DATE	08.03.06	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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